

Work Order ID 146232

Friday, May 13, 2016 10:10:02 AM

146232

Page 1

Item ID: D3885-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Standard Web
 Start Date: 5/13/2016 Start Qty: 25.00 ***25*** Cust Item ID:
 Required Date: 6/3/2016 Req'd Qty: 25.00 ***25*** Customer:

Reference: DAS
 Approvals: Process Plan: 13 D MAY 16 2016 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3885	C								

102 0.00 **DAS**
102 13
 Skidtubes 4.00 9-89
 Skidtubes Memo CUT BLANK TO 115.00" 25 MAY 17 2016

@ wejay

105 0.00
105
 QC Memo 0.50
 Quality Control

QC5- Inspect part completeness to step on W/O

Memo

[Handwritten signature]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval 		
Description Work Order Deviation				Disposition					
				Completed By					
				Lead hand / Supervisor Approval Verification					
				QC / QA Coordinator Approval					

Root Cause			FAULT CATEGORY							
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design ☐	☐	Operator	☐	Bending *	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date ☐	☐	Manufacturing Process	OTHER :							
Misidentified ☐	☐	Past Due								

Work Order ID 146232

Friday, May 13, 2016 10:10:02 AM

146232

Page 3

Item ID: D3885-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Standard Web

Start Date: 5/13/2016 Start Qty: 25.00

25

Cust Item ID:

Required Date: 6/3/2016 Req'd Qty: 25.00

25

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 4.25	> 16-6-20 H.G./BB						
140 *140* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.25	16-6-20						
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: LG002 Memo LOCATION : LG002	0.00 0.25	16-6-20 H.G./						

DAS
19
8-8916-6-20 H.G./
OK

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval				
Description Work Order Deviation				Disposition							
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter		FAULT CATEGORY		☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes		☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center		☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence	
		☐ OTHER : _____									

Work Order ID 146232

Friday, May 13, 2016 10:10:03 AM

146232

Page 4

Item ID: D3885-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Standard Web

Start Date: 5/13/2016 Start Qty: 25.00

25

Cust Item ID:

Required Date: 6/3/2016 Req'd Qty: 25.00

25

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

2.50

Quality Control

GK 6/24/16

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : ☐							
Misidentified ☐	Past Due ☐								

Picklist Print

Friday, May 13, 2016 10:10:02 AM

Page 1

Work Order ID: 146232

146232

Parent Item: D3885-1

D3885-1

Parent Item Name: Standard Web

Start Date: 5/13/2016

Required Date: 6/3/2016

Start Qty: 25.00

Required Qty: 25.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3882-1-130		Manufactured	No			110	Each	67.0000	1	25			

D3882-1-130

Extrusion "I" Beam

Location

WEJAY

119702

137403

Loc Qty

67

2

65

Each

Loc Code

0.0000

D3885-1P

Purchased

No

D3885-1P

Standard Web

25
u 16-05-17
u 16-05-17

DQA: _____ Date: _____



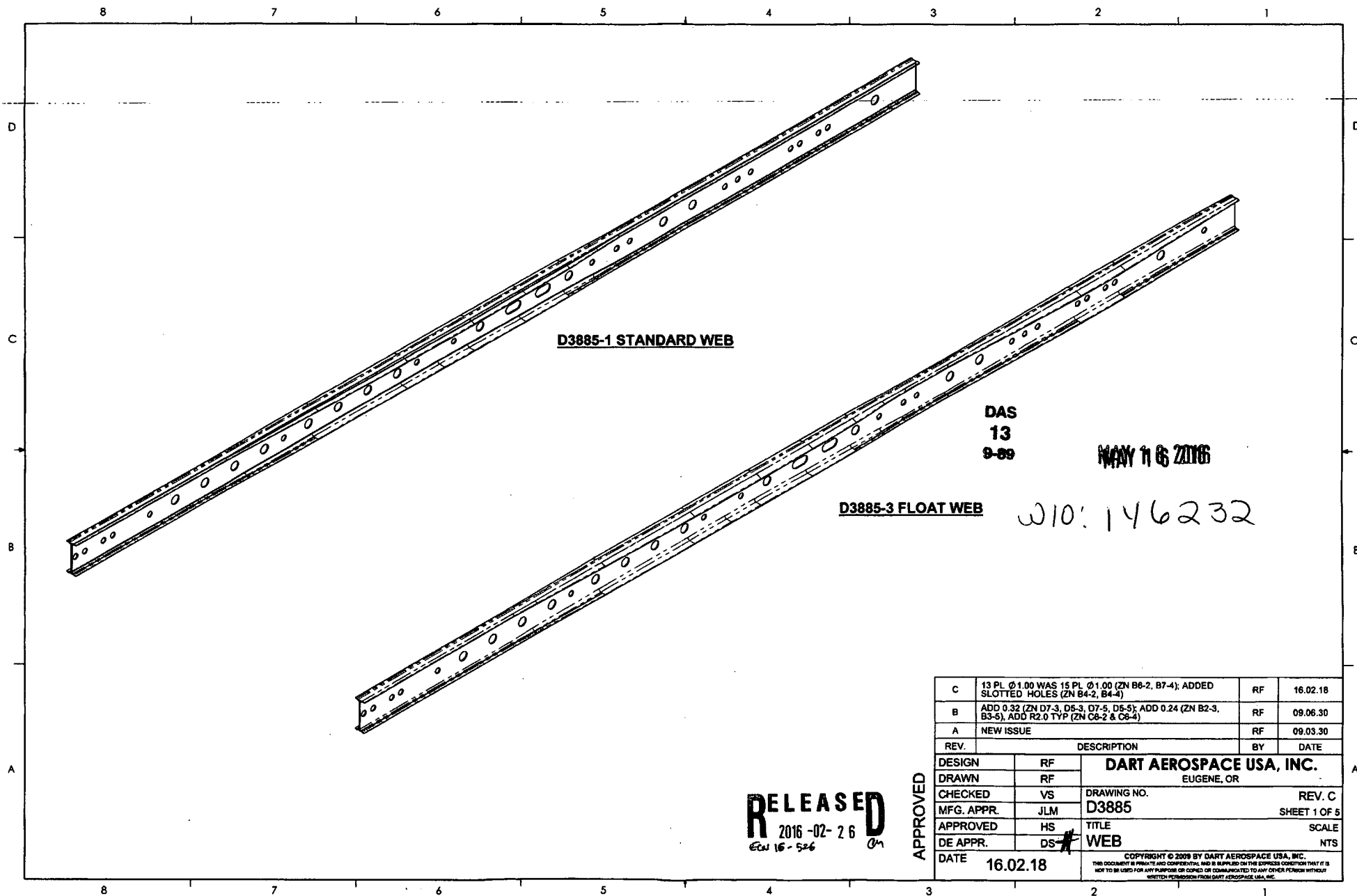
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

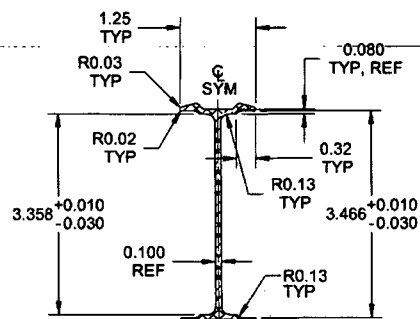
Root Cause				FAULT CATEGORY			
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions		
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance		
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect		
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved		
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing		
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish		
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread		
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence		
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____					
Misidentified ☐	☐ Past Due						



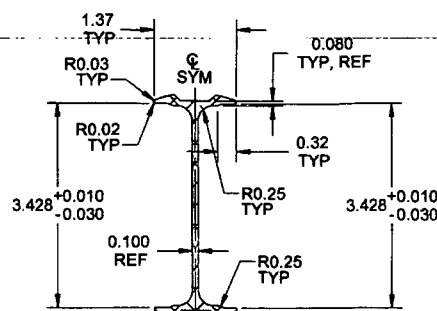
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2016-02-26
ECN 16-526

APPROVED

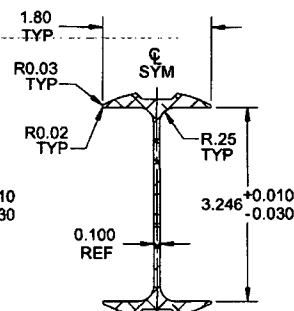
C	13 PL Ø1.00 WAS 15 PL Ø1.00 (ZN B6-2, B7-4); ADDED SLOTTED HOLES (ZN B4-2, B4-4)	RF	16.02.18
B	ADD 0.32 (ZN D7-3, D5-3, D7-5, D5-5); ADD 0.24 (ZN B2-3, B3-5); ADD R2.0 TYP (ZN C8-2 & C8-4)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. C
MFG. APPR.	JLM	D3885	SHEET 1 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	WEB	NTS
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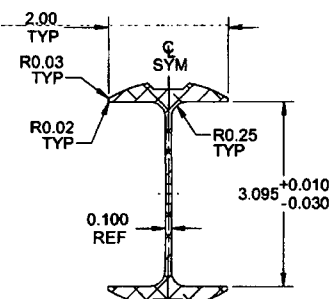
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& SECTION J-J**
SCALE 5X
D6-2
D4-2



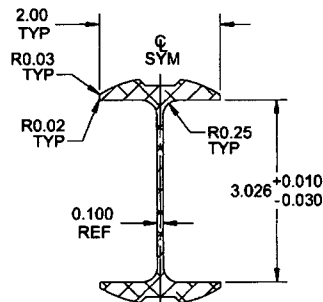
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D6-2



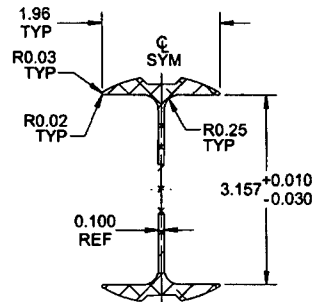
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SCALE 5X
D6-2



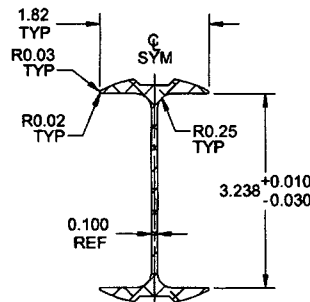
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D6-2



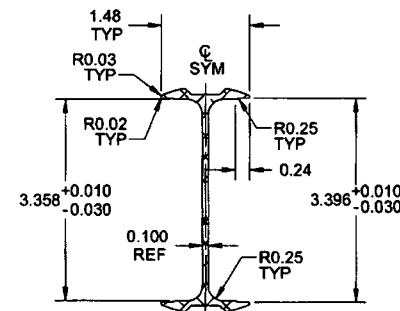
**SECTION E-E
& SECTION F-F**
SCALE 5X
D6-2



SECTION G-G
SCALE 5X
D4-2



SECTION H-H
SCALE 5X
D4-2



SECTION I-I
SCALE 5X
D4-2

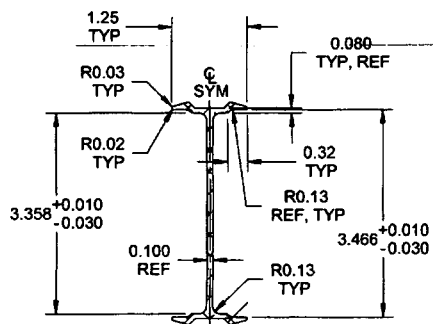
D3885-1 STANDARD WEB SECTION VIEWS

RELEASED
2016-02-26

APPROVED

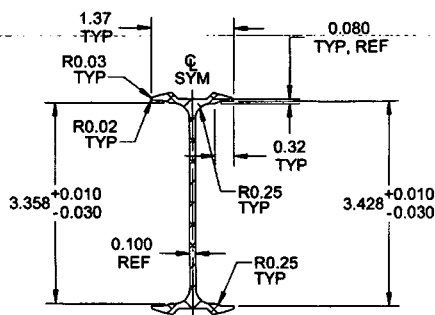
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	EUGENE, OR	
CHECKED	VS	DRAWING NO.	REV. C
MFG. APPR.	JLM	D3885	SHEET 3 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	WEB	NTS
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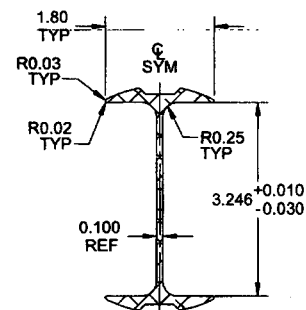


**SECTION K-K
& SECTION T-T
& SECTION U-U
& SECTION X-X**
SCALE 5X

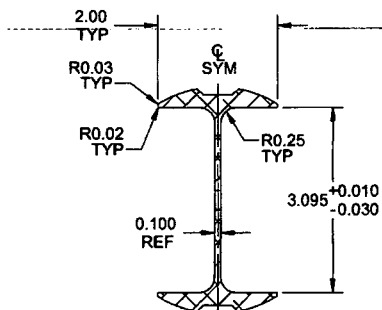
D7-4
D4-4
D3-4
D1-4



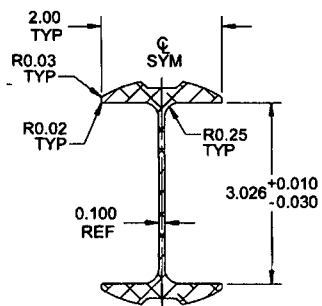
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SCALE 5X



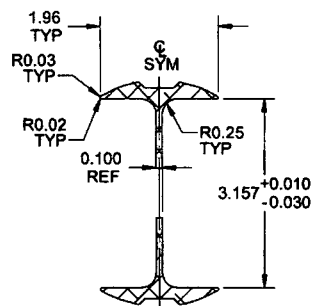
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SCALE 5X



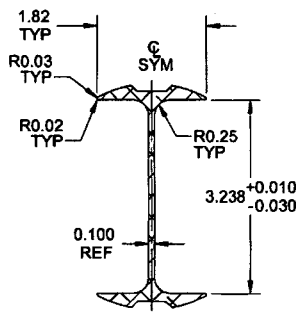
SECTION N-N D5-4
SCALE 5X



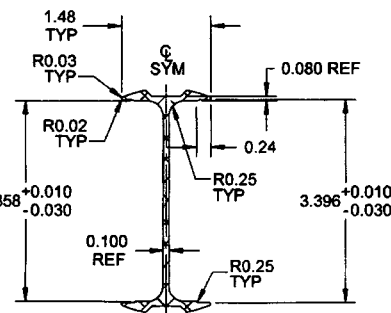
**SECTION O-O
& SECTION P-P** D5-4
SCALE 5X



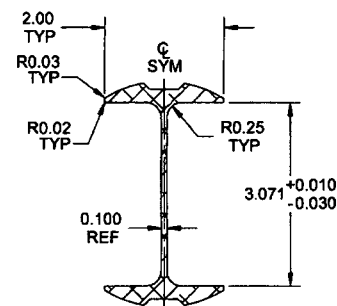
SECTION Q-Q D4-4
SCALE 5X



SECTION R-R D4-4
SCALE 5X



SECTION S-S D4-4
SCALE 5X



**SECTION V-V
& SECTION W-W** D3-4
D2-4
SCALE 5X

D3885-3 FLOAT WEB SECTION VIEWS

RELEASED
2016-02-26

APPROVED

DESIGN	RF	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. C
MFG. APPR.	JLM	D3885	SHEET 5 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	WEB	NTS
DATE	16.02.18	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO32402**

Purchase Order Date 5/17/2016 2:48:33 PM
PO Print Date 5/17/2016

Page Number 1 of 2

Order From :

VC-WMP001

WEJAY MACHINE PRODUCTS CO. LTD
600 O'CONNOR DRIVE
KINGSTON, ONTARIO K7P 1N3
CANADA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED

MAY 17 2016

Contact Name
Vendor Phone 613-384-1662

Ship To Contact
Ship To Phone
Ship Via: Journey Freight collect
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D3885-1P	Standard Web	6/8/2016 Yes 6/8/2016		25.00 Each	\$495.00	\$12,375.00
AS PER DWG D3885 REV. C B146232							
Line Total:							\$12,375.00
3	71401-45	PROCUREMENT QUALITY CLAUSES	6/8/2016 No 6/8/2016		1.00	\$0.00	\$0.00
Procurement Quality Clauses A005 RIGHT OF ENTRY A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION SENT TO DART AEROSPACE) A016 PERSONNEL QUALIFICATION A024 PROCESS CERTIFICATIONS A025 CERTIFICATE OF CONFORMANCE A040 NOTIFICATION OF QUALITY ESCAPE A042 DART NOTIFICATION BY SUPPLIER A043 RETENTION OF QUALITY DOCUMENTS							

Note:

5/17/2016

NO GOODS RETURNED WITHOUT
PRIOR AUTHORIZATION



600 O'CONNOR DRIVE, KINGSTON, ONTARIO K7P 1N3

PHONE: (613) 384-1662

FAX: (613) 384-2997

CERTIFICATE OF COMPLIANCE

CUSTOMER: Dart Aerospace		DATE: June 13, 2016	
		P.O.# PO32402	
		WEJAY JOB# 38007	
I hereby certify that the following material has been inspected/tested and conforms to the requirements and specifications as stated in your contract and as noted below.			
PART NO.	QTY.	PROCESS (ES)	SPECIFICATION / REV
D3885-1P 'Standard Web' B146232	25	Machined complete per drawing req'ts.	D3885 / rev. C
Note: 1) Material: Aluminum extrusions supplied by Dart Aerospace. 2) 1st Article and Final Inspection/ Test Reports attached.			

Records of Inspection/Test will be retained for 5 years minimum.

Sincerely,

Clifford Smith
Authorized Q.A. Signatory



600 O'CONNOR DRIVE
KINGSTON, ONTARIO
K7P 1N3

INSPECTION / TEST REPORT

JOB No.38007

PAGE: 1 of 3

CUSTOMER: Dart Aerospace

CUST. P.O.# PO32402

PART No. D3885-1P

DESCRIPTION: Standard Web

DWG No. D3885 - sheets 2-3

REV. C

E.C.O. --

MATERIAL: Extrusions supplied by DAS

INSPECTOR: Paul Roosen

QUANTITY
REC'D: 1

ACCEPT:
1

REJECT:
--

N.C.R.#
--

DATE: June 1, 2016



INSTRUCTIONS, COMMENTS: 1st ARTICLE INSPECTION / FINAL INSPECTION

ITEM REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)
1	Hole, Ø .63"	18 places	+ .008/- .001		.6325	1	Accepted
2	Hole, Ø 1.00"	13 places	+ .010/- .001		1.001	1	Accepted
3	Slot, R 0.50	2 places	+ .010/- .001		.50	1	Accepted
4	5.51"		± .03		5.513	1	Accepted
5	11.86"		± .03		11.855	1	Accepted
6	13.11"		± .03		13.105	1	Accepted
7	15.61"		± .03		15.604	1	Accepted
8	16.86"		± .03		16.853	1	Accepted
9	22.29"		± .03		22.289	1	Accepted
10	24.04"		± .03		24.038	1	Accepted
11	25.79"		± .03		25.786	1	Accepted
12	30.14"		± .03		30.128	1	Accepted
13	34.14"		± .03		34.128	1	Accepted
14	38.67"		± .03		38.66	1	Accepted
15	40.42"		± .03		40.409	1	Accepted
16	43.71"		± .03		43.702	1	Accepted
17	46.91"		± .03		46.898	1	Accepted
18	49.91"		± .03		49.896	1	Accepted
19	50.91"		± .03		50.898	1	Accepted
20	53.91"		± .03		53.897	1	Accepted
21	54.91"		± .03		54.898	1	Accepted
22	58.91"		± .03		58.896	1	Accepted
23	62.43"		± .03		62.42	1	Accepted
24	67.43"		± .03		67.42	1	Accepted
25	70.10"		± .03		70.082	1	Accepted
26	74.10"		± .03		74.082	1	Accepted
27	78.10"		± .03		78.082	1	Accepted
28	82.10"		± .03		82.082	1	Accepted
29	85.43"		± .03		85.419	1	Accepted

INSPECTION / TEST REPORT						JOB No. 38007	
						PAGE: 2 of 3	
CUSTOMER: Dart Aerospace							
CUST. P.O PO32402							
PART No. D3885-1				DESCRIPTION: Standard Web			
DWG No. D3885 - sheets 2-3				REV. C		E.C.O. --	
REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)

30	88.01"		± .03		87.999	1	Accepted
31	92.01"		± .03		91.999	1	Accepted
32	96.01"		± .03		95.998	1	Accepted
33	100.01"		± .03		99.997	1	Accepted
34	103.43"		± .03		103.415	1	Accepted
35	108.42"		± .03		108.404	1	Accepted
36	109.67"		± .03		109.654	1	Accepted
37	112.17"		± .03		112.153	1	Accepted
38	113.42"		± .03		113.402	1	Accepted
39	113.92" o.a.		± .03		113.902	1	Accepted
40	1.25" TYP	Section A-A, J-J	± .03		1.270- 1.279	1	Accepted
41	R.03" TYP		± .03		R .03 typ.	1	Accepted
42	R.02" TYP		± .03		R .02 typ.	1	Accepted
43	3.358"		+0.010/-0.030		3.356	1	Accepted
44	R.13" TYP		± .03		R .13 typ.	1	Accepted
45	.32" TYP		± .03		.320	1	Accepted
46	3.466"		+0.010/-0.030		3.456- 3.475	1	Accepted
47	R.13" TYP		± .03		R .13 typ.	1	Accepted
48	.080 TYP,REF		± .03		.080 typ.	1	Accepted
49	1.37" TYP	Section B-B	± .03		1.382	1	Accepted
50	R.03" TYP		± .03		R .03 typ.	1	Accepted
51	R.02" TYP		± .03		R .03 typ.	1	Accepted
52	3.358"		+0.010/-0.030		3.358	1	Accepted
53	R.25" TYP		± .03		R .02 typ.	1	Accepted
54	.32" TYP		± .03		.320	1	Accepted
55	R.25" TYP		± .03		R .25 typ.	1	Accepted
56	3.428"		+0.010/-0.030		3.412- 3.438	1	Accepted
57	1.80" TYP	Section C-C	± .03		1.812- 1.819	1	Accepted
58	R.03" TYP		± .03		R .03 typ.	1	Accepted
59	R.02" TYP		± .03		R .03 typ.	1	Accepted
60	3.246"		+0.010/-0.030		3.235- 3.243	1	Accepted
61	R.25" TYP		± .03		R .25 typ.	1	Accepted
62	2.00" TYP	Section D-D	± .03		1.985 typ.	1	Accepted
63	R.03" TYP		± .03		R .03 typ.	1	Accepted
64	R.02" TYP		± .03		R .03 typ.	1	Accepted

INSPECTION / TEST REPORT						JOB No. 38007	
						PAGE: 3 of 3	
CUSTOMER: Dart Aerospace							
CUST. P.O PO32402							
PART No.D3885-1				DESCRIPTION: Standard Web			
DWG No. D3885 - sheets 2-3				REV. C		E.C.O. --	
REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)

65	3.095"		+ .010/- .030		3.080- 3.103	1	Accepted
66	R.25" TYP		± .03		R .25 typ.	1	Accepted
67	2.00" TYP	Section E-E, F-F	± .03		1.987 typ.	1	Accepted
68	R.03" TYP		± .03		R .03 typ.	1	Accepted
69	R.02" TYP		± .03		R .03 typ.	1	Accepted
70	3.026"		+ .010/- .030		3.02-3.04	1	Accepted
71	R.25" TYP		± .03		R .25 typ.	1	Accepted
72	1.96"	Section G-G	± .03		1.970	1	Accepted
73	R.03" TYP		± .03		R .03 typ.	1	Accepted
74	R.02" TYP		± .03		R .03 typ.	1	Accepted
75	3.157		+ .010/- .030		3.145- 3.166	1	Accepted
76	R.25" TYP		± .03		R .25 typ.	1	Accepted
77	1.82"	Section H-H	± .03		1.827	1	Accepted
78	R.03" TYP		± .03		R .03 typ.	1	Accepted
79	R.02" TYP		± .03		R .03 typ.	1	Accepted
80	3.238"		+ .010/- .030		3.230- 3.245	1	Accepted
81	R.25" TYP		± .03		R .25 typ.	1	Accepted
82	1.48"	Section I-I	± .03		1.495	1	Accepted
83	R.03" TYP		± .03		R .03 typ.	1	Accepted
84	R.02" TYP		± .03		R .03 typ.	1	Accepted
85	3.358		+ .010/- .030		3.360	1	Accepted
86	R.25" TYP		± .03		R .25 typ.	1	Accepted
87	3.396"		+ .010/- .030		3.384- 3.405	1	Accepted
88	R.25" TYP		± .03		R .25 typ.	1	Accepted



600 O'CONNOR DRIVE
KINGSTON, ONTARIO
K7P 1N3

INSPECTION / TEST REPORT

JOB No.38007

PAGE: 1 of 3

CUSTOMER: Dart Aerospace

CUST. P.O.# PO32402

PART No. D3885-1P

DESCRIPTION: Standard Web

DWG No. D3885 - sheets 2-3

REV. C

E.C.O. --

MATERIAL: Extrusions supplied by DAS

INSPECTOR: Cliff Smith

QUANTITY
REC'D: 1

ACCEPT:
1

REJECT:
--

N.C.R.#
--

DATE: June 13, 2016

WMP
03

INSTRUCTIONS, COMMENTS: 1st ARTICLE INSPECTION / **FINAL INSPECTION**

ITEM REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)
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1	Hole, Ø .63"	18 places	+ .008/- .001		.633 typ.	1	Accepted
2	Hole, Ø 1.00"	13 places	+ .010/- .001		1.001- 1.002	1	Accepted
3	Slot, R 0.50	2 places	+ .010/- .001		R .501 typ.	1	Accepted
4	5.51"		± .03		5.514	1	Accepted
5	11.86"		± .03		11.857	1	Accepted
6	13.11"		± .03		13.107	1	Accepted
7	15.61"		± .03		15.607	1	Accepted
8	16.86"		± .03		16.858	1	Accepted
9	22.29"		± .03		22.293	1	Accepted
10	24.04"		± .03		24.043	1	Accepted
11	25.79"		± .03		25.794	1	Accepted
12	30.14"		± .03		30.135	1	Accepted
13	34.14"		± .03		34.135	1	Accepted
14	38.67"		± .03		38.668	1	Accepted
15	40.42"		± .03		40.419	1	Accepted
16	43.71"		± .03		43.711	1	Accepted
17	46.91"		± .03		46.908	1	Accepted
18	49.91"		± .03		49.910	1	Accepted
19	50.91"		± .03		50.910	1	Accepted
20	53.91"		± .03		53.910	1	Accepted
21	54.91"		± .03		54.910	1	Accepted
22	58.91"		± .03		58.909	1	Accepted
23	62.43"		± .03		62.433	1	Accepted
24	67.43"		± .03		67.433	1	Accepted
25	70.10"		± .03		70.096	1	Accepted
26	74.10"		± .03		74.096	1	Accepted
27	78.10"		± .03		78.095	1	Accepted
28	82.10"		± .03		82.095	1	Accepted
29	85.43"		± .03		85.431	1	Accepted

INSPECTION / TEST REPORT						JOB No. 38007	
						PAGE: 2 of 3	
CUSTOMER: Dart Aerospace							
CUST. P.O. PO32402							
PART No. D3885-1				DESCRIPTION: Standard Web			
DWG No. D3885 - sheets 2-3				REV. C		E.C.O. --	
REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)

30	88.01"		± .03		88.012	1	Accepted
31	92.01"		± .03		92.011	1	Accepted
32	96.01"		± .03		96.011	1	Accepted
33	100.01"		± .03		100.010	1	Accepted
34	103.43"		± .03		103.430	1	Accepted
35	108.42"		± .03		108.419	1	Accepted
36	109.67"		± .03		109.669	1	Accepted
37	112.17"		± .03		112.169	1	Accepted
38	113.42"		± .03		113.418	1	Accepted
39	113.92" o.a.		± .03		113.919	1	Accepted
40	1.25" TYP	Section A-A, J-J	± .03		1.248- 1.273	1	Accepted
41	R.03" TYP		± .03		R .03 typ.	1	Accepted
42	R.02" TYP		± .03		R .02 typ.	1	Accepted
43	3.358"		+0.010/-0.030		3.358-3.366	1	Accepted
44	R.13" TYP		± .03		R .125 typ.	1	Accepted
45	.32" TYP		± .03		.325-.330	1	Accepted
46	3.466"		+0.010/-0.030		3.457- 3.475	1	Accepted
47	R.13" TYP		± .03		R .125 typ.	1	Accepted
48	.080 TYP,REF		± .03		.069- .076	1	Accepted
49	1.37" TYP	Section B-B	± .03		1.376- 1.381	1	Accepted
50	R.03" TYP		± .03		R .03 typ.	1	Accepted
51	R.02" TYP		± .03		R .02 typ.	1	Accepted
52	3.358"		+0.010/-0.030		3.354- 3.361	1	Accepted
53	R.25" TYP		± .03		R .25 typ.	1	Accepted
54	.32" TYP		± .03		.325- .330	1	Accepted
55	R.25" TYP		± .03		R .25 typ.	1	Accepted
56	3.428"		+0.010/-0.030		3.422- 3.437	1	Accepted
57	1.80" TYP	Section C-C	± .03		1.811 typ.	1	Accepted
58	R.03" TYP		± .03		R .03 typ.	1	Accepted
59	R.02" TYP		± .03		R .02 typ.	1	Accepted
60	3.246"		+0.010/-0.030		3.240- 3.255	1	Accepted
61	R.25" TYP		± .03		R .25 typ.	1	Accepted
62	2.00" TYP	Section D-D	± .03		1.985- 1.986 (stock)	1	Accepted
63	R.03" TYP		± .03		R .03 typ.	1	Accepted
64	R.02" TYP		± .03		R .02 typ.	1	Accepted

INSPECTION / TEST REPORT						JOB No. 38007	
						PAGE: 3 of 3	
CUSTOMER: Dart Aerospace							
CUST. P.O. PO32402							
PART No. D3885-1				DESCRIPTION: Standard Web			
DWG No. D3885 - sheets 2-3				REV. C		E.C.O. --	
REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)

65	3.095"		+ .010/- .030		3.087- 3.105	1	Accepted
66	R.25" TYP		± .03		R .25 typ.	1	Accepted
67	2.00" TYP	Section E-E, F-F	± .03		1.985- 1.986 (stock)	1	Accepted
68	R.03" TYP		± .03		R .03 typ.	1	Accepted
69	R.02" TYP		± .03		R .02 typ.	1	Accepted
70	3.026"		+ .010/- .030		3.008- 3.043 (stock)	1	Accepted
71	R.25" TYP		± .03		R .25 typ.	1	Accepted
72	1.96"	Section G-G	± .03		1.968- 1.975	1	Accepted
73	R.03" TYP		± .03		R .03 typ.	1	Accepted
74	R.02" TYP		± .03		R .02 typ.	1	Accepted
75	3.157		+ .010/- .030		3.145- 3.169	1	Accepted
76	R.25" TYP		± .03		R .25 typ.	1	Accepted
77	1.82"	Section H-H	± .03		1.824- 1.829	1	Accepted
78	R.03" TYP		± .03		R .03 typ.	1	Accepted
79	R.02" TYP		± .03		R .02 typ.	1	Accepted
80	3.238"		+ .010/- .030		3.226- 3.246	1	Accepted
81	R.25" TYP		± .03		R .25 typ.	1	Accepted
82	1.48"	Section I-I	± .03		1.487- 1.498	1	Accepted
83	R.03" TYP		± .03		R .03 typ.	1	Accepted
84	R.02" TYP		± .03		R .02 typ.	1	Accepted
85	3.358		+ .010/- .030		3.345- 3.364	1	Accepted
86	R.25" TYP		± .03		R .25 typ.	1	Accepted
87	3.396"		+ .010/- .030		3.385- 3.406	1	Accepted
88	R.25" TYP		± .03		R .25 typ.	1	Accepted